Work Order January 6, 2011 7	•											Page 1
Revision ID:	93537-1 /earpad			Accept					Setup	Start Stop		
Start Date: 1/ Required Date: 1/ Reference:		art Qty: 40.00 q'd Qty: 40.00			Cust Item I Customer:	D:					1 13 MILLON	
· •	Process Plan:		Date:	Tooling: SPC (Y/N):	•	ate:			Run	Start Stop	1 12211101 1	
Sequence ID/ Work Center ID		eration cription	,	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision									·		~ tmp
D3537	Rev C											
Waterjet FLOW CNC Waterjet	FLO	W WATER JET Memo 1-Cut as p if necessar		0.00 . 0.00 g Rev: <u>C</u> □Prog Rev: <u>(</u>	☐2-Deburr			RS i	<u>l- (- (</u>	6	48)	
QC Quality Control	QC2	2- Inspect parts off Memo	machine FAI/FAIB	0.00				HB/	<u> </u>	Φ_	• • • • • • • • • • • • • • • • • • •	
120 	QC8	3- Inspect parts - se Memo	cond check	0.00 2 (1)	106		ı	count	\			

Quality Control

Dart Ae	rospace	Ltd							E * \$
W/O:				WORK ORDER	CHANGES				
DATE	STEP		PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•		PAR #:	Fault Category:	NCR: Y	es No DQ	Á:	Date: _	
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NCR:			•	WORK ORDER NON-CON	FORMANCE (N	CR)			

NCR:		>	WORK OR	DER NON-CONFORMAN	CE (NCR)				
	T	Description of NC		Corrective Action Section E	<u> </u>	Verification	Anneoval	Annroyal	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector	
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January 6, 2011 7:17:26 AM

Item ID: **Revision ID:** D3537-1

Item Name: Wearpad

Start Date:

1/05/11

Start Qty: 40.00

Reference:



Accept

Cust Item ID:

Customer:

Setup Start

Stop



Required Date: 1/14/11 Req'd Qty: 40.00

Approvals:

Date: Tooling:

Date: SPC (Y/N):

Date:

Date:

Tool # Plan

Code

Start Run

Accept

Qty

Stop

Reject

Qty



Number Stamp

Insp.

Sequence ID/ **Work Center ID**

130

Brake NC

Brake NC

Operation Description

NC BRAKE

Set Up/ **Run Hours**

0.00

Tool ID

0.00

0.00

0.00

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. D2-

Identify as D3537-1

Si Illoilu

140



Large Fab Large Fab

Large Fab

Memo

Memo

Description

QC10- Inspect visual per QSI004- ground welds

Batch □ A/R

2059B Hardcoat

M 11.464 DI-Weld as per Dwg D3537 using Jig DT 8210 D2-Remove any

weld that penetrated through Wearpadif necessary

150



Quality Control

Memo

Q 71-1-31

Reject

Lourto

W/O: WORK ORDER CHANGES						÷		
DATE	STEP	PRC	CEDURE CHA	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC			ion B	Verification	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Work Order ID 65057

January 6, 2011 7:17:27 AM



Page 3

Item ID:

D3537-1

Wearpad

Item Name: **Start Date:**

Revision ID:

1/05/11

QC:

Required Date: 1/14/11

Start Qty: 40.00



Accept



Setup Start

Stop



Req'd Qty: 40.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: Date:

Date:

Tooling:

SPC (Y/N):

Date: Date:

Stop

Start



Sequence ID/

Work Center ID

160

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours**

Sulvel3 1

Tool ID

Tool # Plan

Code **Qty**

Reject Accept Qty

Run

Reject Number Stamp

18 BR 11-02-1

Insp.

170

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

M115128

Memo

0.00

□OVEN TEMPERATURE:

0.00

180

Quality Control

Memo

QC3- Inspect Part Finish

0.00

0.00

M (=

11/02/01 -48

W/O:			V	ORK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Ca	tegory:	NCR	R: Yes N	io DQ	A:	Date:	
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DATE	STEP	Description of NC	Corrective Action Section E			I VARI			Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
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Work Order ID 65057

January 6, 2011 7:17:27 AM



Page 4

Item ID:

D3537-1

Revision ID: Item Name:

Wearpad

Start Date:

Start Qty: 40.00

1/05/11 Required Date: 1/14/11

Req'd Qty: 40.00



Customer:

Cust Item ID:

Reference:

Approvals:

Process Plan:

QC:

Date:_

Date:

Tooling: SPC (Y/N):

Set Up/

Run Hours

Accept

Tool ID

Date:

Date:

Tool # Plan Code

Accept Qty

Reject Qty

Run

Setup Start

Stop

Start

Stop

Reject Number Stamp

Insp.

Sequence ID/ Work Center ID 190

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

0.00

200

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W/O:			W	ORK ORDER CHANGE	ES				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	Date:	
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NCR:		,	WORK ORE	DER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section		Sign & Verific		Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Dat		tion C	Chief Eng	QC Inspector
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								-	

Picklist Print

January 6, 2011 7:17:25 AM

Work Order ID: 65057

Parent Item:

D3537-1

Parent Item Name:

Wearpad



Start Date: 1/05/11

Required Date: 1/14/11

Page 1

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	- .	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	56.4100	0.106	4.463158		5.1	
										ıß	14-1	-6	

304/316 Sheet .063

Location	Loc Qty	Loc Code		•
MAT	56.41			Lg.
111323	0			(O 17)
115953	56.41		115953	\bigcirc

W/O:			GES		.,.					
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	.	PAR #:	Fault Ca	tegory:	NCI	R: Yes I	No DQ	A:	_ Date: _	
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NCR:			WORK OR	DER NON-CONFORM	IANCE	(NCR	· ·			
DATE	STEP	Description of NC		Corrective Action Section B			Verifi	cation	Approval	Approval
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DART AEROSPACE LTD	Work Order:	65057
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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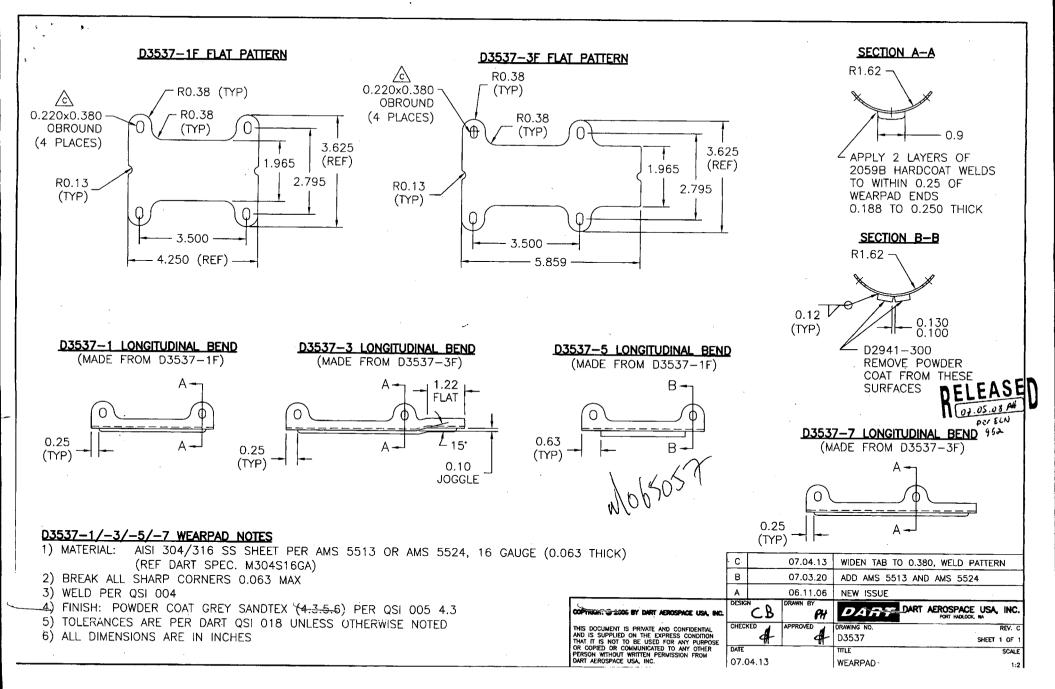
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.250	+/-0.010	4.253	٧		V 1802	
3.500	+/-0.010	3,501	7		ν	
1.965	+/-0.010	1,966	7		U	
2.795	+/-0.010	2.794	8		ν	
3.625	+/-0.010	3,604	8		V	
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Measured by:	AR.	Audited by:	Prototype Approval:	N/A
Date:	11-1-6	Date: "Jallob	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.03.21	New Issue	KJ/JLM	
В	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
С	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM 🔏	all

DATE STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr QC inspector Part No:PAR #: Fault Category:NCR: Yes No DQA:Date: Resolution:Disposition:QA: N/C Closed:Date: NCR: WORK ORDER NON-CONFORMANCE (NCR) DATE STEP Description of NC	W/O:			WORK ORDER CHANGES							
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Hi/IFORMS/Quality Assurance/approved QA/NCRWO RevE



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